

What is claimed is:

1. A microreplicated article comprising:
a flexible substrate having first and second opposed surfaces;
5 a first coated microreplicated pattern on the first surface; and
a second coated microreplicated pattern on the second surface, wherein the first and
second patterns are registered to within 100 microns in a cross-web direction.
- 10 2. The article of claim 1, wherein the first microreplicated pattern includes a plurality of
cylindrical lenses.
3. The article of claim 2, wherein the second microreplicated pattern includes a plurality
of symmetric prisms.
- 15 4. The article of claim 3, wherein first and second microreplicated patterns cooperate to
form a plurality of lenticular lenses.
5. The article of claim 4, wherein the lenses have a pitch of about 150 microns in a cross-
web direction.
- 20 6. The article of claim 5, wherein the substrate material is polyethylene terephthalate.
7. The article of claim 6, further including a first land area between the first
microreplicated pattern and the web and a second land area between the second
25 microreplicated pattern and the web.
8. The article of claim 7, wherein the first land area is at least about 10 microns.
9. The article of claim 8, wherein the second land area is at least about 25 microns.

10. The article of claim 9, wherein the cylindrical lenses have an effective diameter of about 142 microns and the symmetrical prisms have an included angle of about 60 degrees.

5 11. A method of making a microreplicated article including a web substrate having first and second opposed surfaces, the method comprising:

passing the web through a casting apparatus;

coating a first liquid on the first surface;

contacting the first liquid with a first patterned roll;

10 curing the first liquid to create the first microreplicated pattern;

coating a second liquid on the second surface;

contacting the second liquid with a second patterned roll while the first microreplicated pattern is in contact with the first pattern roll; and

15 curing the second liquid to create the second microreplicated pattern, wherein the first and second patterns are registered to within about 100 microns in a cross-web direction.

12. The method of claim 11, wherein said passing a web includes passing a web made of polyethylene terephthalate.

20 13. The method of claim 11, wherein said contacting the first liquid includes contacting a light sensitive acrylate resin solution.

14. The method of claim 12, wherein said contacting the second liquid includes contacting a light sensitive acrylate resin solution.

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15. The method of claim 11, wherein said step of contacting the first liquid with the first patterned roll further includes contacting the first liquid with the first patterned roll, wherein the first patterned roll includes a plurality of symmetrical arcuately-shaped features.

16. The method of claim 11, wherein said step of contacting the second liquid with the second patterned roll further includes contacting the second liquid with the second patterned roll, wherein the second patterned roll includes a plurality of symmetrical prism-shaped features.

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17. The method of claim 16, further including forming a first land area between the web and the first microreplicated pattern.

18. The method of claim 17, further including forming a second land area between the web and the second microreplicated pattern.

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19. An article comprising a web having first and second opposed surfaces, the web further having a first microreplicated pattern on the first surface and a second microreplicated pattern on the second surface, wherein the first and second microreplicated patterns cooperate to form a plurality of lenticular lens features, the article made by a method comprising:

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passing the web through a casting apparatus;

coating a first liquid on the first surface;

contacting the first liquid with a first patterned roll;

curing the first liquid to create the first microreplicated pattern;

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coating a second liquid on the second surface;

contacting the second liquid with a second patterned roll while the first microreplicated pattern is in contact with the first pattern roll; and

curing the second liquid to create the second microreplicated pattern, wherein the first and second patterns are registered to within about 100 microns.

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20. An method of making an article including a plurality of microreplicated lens features, the method comprising:
providing a substrate, in web form, having first and second opposed surfaces;

passing the substrate through a casting apparatus to form a plurality of lens features, wherein the lens features are comprised of:

a first microreplicated patterned structure on the first surface and a second microreplicated patterned structure on the second surface, wherein the first and second structures are

5 registered to within about 100 microns.

21. The method of claim 20, wherein the lens features are lenticular lenses.

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